

Date: Friday, 13/02/2009 1:02:30 PM
User: Julie Dawson

Fire Red

Dart Aerospace Ltd.

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 45791
Estimate Number : 11345
P.O. Number :
This Issue : 13/02/2009 S.O. No. :
Prsht Rev. : NC
First Issue : // Type : MACHINED PARTS
Previous Run : 44287
Drawing Name : PEDAL LOCK BASE
Part Number : D33701
Drawing Number : D3370 REV C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 20/02/2009 Qty: 6 Um: Each
Written By :
Checked & Approved By : Julie Dawson
Comment : Est. B 05.05.25 Added Powder Coat KJ/JLM
Est Rev:C 08-07-17 revC as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1500X02500 6061-T6 Bar 1.50 x 2.50



Batch: M116716



Comment: Qty.: 0.3657 f(s)/Unit Total: 2.1943 f(s)
6061-T6 Bar 1.5" x 2.5"

mk 09/02/15

(8)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: Machine D3368-1 as per Folio FA499 and Dwg D3368
Identify as D3368-1
Deburr

M116716

mk 09/02/15

(PTO)

(6)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 09/02/15

(6)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SP 09/02/17

(6)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

bk 09-02-17

(6)

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME: 7:30am

mk

09-02-17


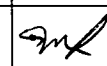
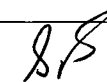


(6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/15	2	2 part scrap, the top broke inside the hole R.C. process.	 16/02/17	scrap, destroy and replace Qty 2 Batch: <u>M16 716</u>	 01/02/15	 09/02/17	 16/02/17	 16/02/17

NOTE: Date & initial all entries

Date: Friday, 13/02/2009 1:02:30 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK BASE

Job Number: 45791

Part Number: D33701

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 320°F

FINISH TIME: 8:00pm

JJ 09-02-16

(46)

(P10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Rec'd 1/8 (6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/19 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector	
09/02/18	6.1	QC3 inspect Powder coat/Chemical conversion Add to J.P.P. Perm change	FL	08/02/18	8			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45791
Description: Pedal Lock Base		Part Number: D3370-1
Inspection Dwg: D3370	Rev: 8C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	—			
0.202	+/-0.010	212	—			
0.592	+/-0.010	.587	—			
0.550	+/-0.010	.550	—			
0.760	+/-0.010	.760	—			
1.50	+/-0.030	1.497	—			
1.188	+/-0.010	1.187	—			
1.232	+/-0.010	1.228	—			
R0.500	+/-0.010	R.500	—			
2.35	+/-0.030	2.358	—			
1.920	+/-0.010	1.920	—			
0.450	+/-0.010	.450	—			
1.673	+/-0.010	1.672	—			
2.638	+/-0.010	2.638	—			
4.00	+/-0.030	4.008	—			
Ø0.203	+0.005/-0.000	Ø.206	—			
0.250	+/-0.030	.234	—			
1.450	+/-0.005	1.454	—			
0.450	+/-0.010	.450	—			
15°	+/-0.1°	15°	—			

Measured by:	<i>[Signature]</i>
Date:	09/02/15

Audited by:	<i>[Signature]</i>
Date:	09/02/17

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	<i>[Signature]</i>

8 7 6 5 4 3 2 1

△C

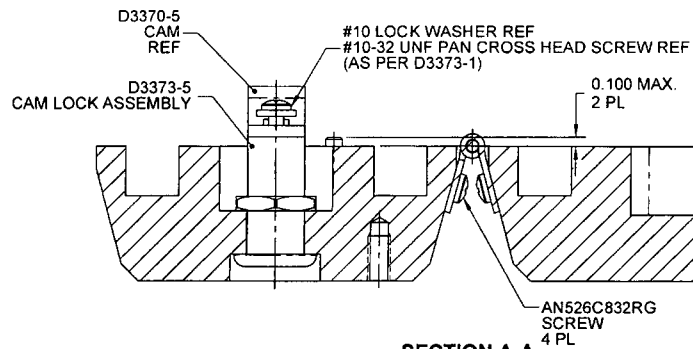
Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D3370-041	TAIL ROTOR DISABLING KIT
1	X	D3370-051	PEDAL LOCK
1		D3384-041	CYCLIC SOCK
1		HX-81	1/4-20 SOCKET HEAD CAP SCREW
2		AN960-416	WASHER
	1	D2728-7	LABEL
	1	D3370-1	BASE
	1	D3370-3	COVER
	1	D3373-5	CAM LOCK ASSY
	1	D3385-3	HINGE
	2	Ø 3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
	4	AN526C832R6	SCREW

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NO 45791

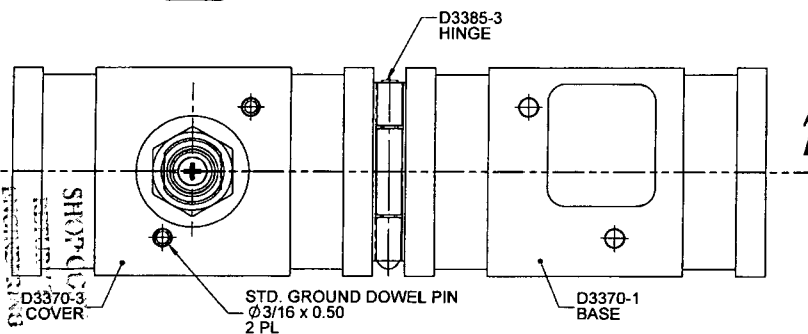
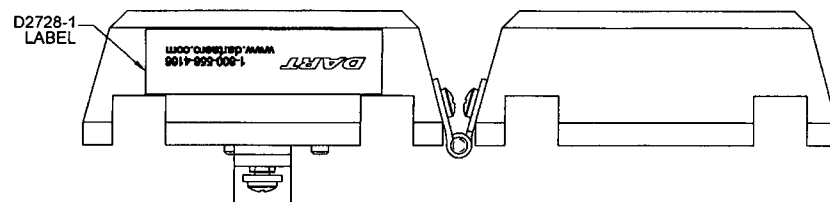
RELEASED
08.07.16

C	SHEET 1 ADDED P/L, ADDED -041 TO P/L (SEE NCR 264). DRAWING TRANSFERRED TO "B" SIZE FORMAT. REFORMATTED TO CURRENT STANDARDS.	AJS	08.07.11
B	D3385-3 WAS D3385-1	MB	05.03.22
A	NEW ISSUE	RF	04.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. C
CHECKED		D3370	SHEET 1 OF 4
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APPROVED		PEDAL LOCK	NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.07.11		

8 7 6 5 4 3 2 1

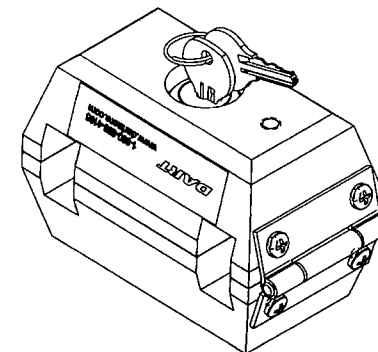


SECTION A-A







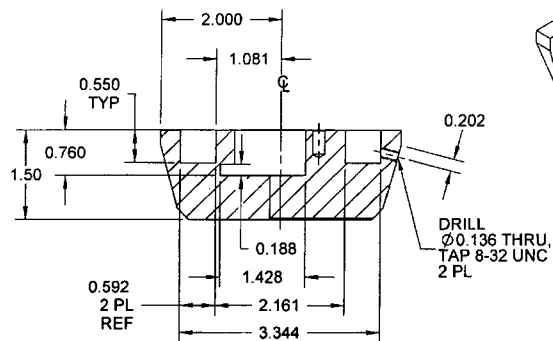
D3370-051 PEDAL LOCK ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.75 lbs

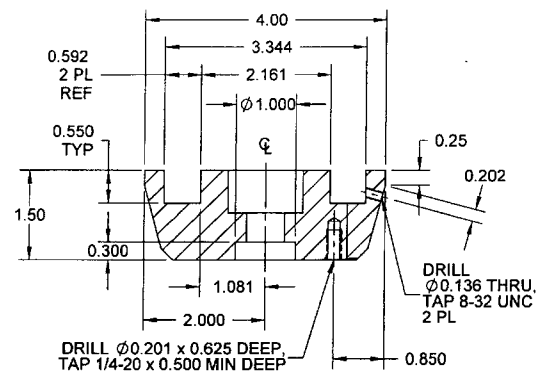


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106-07-12

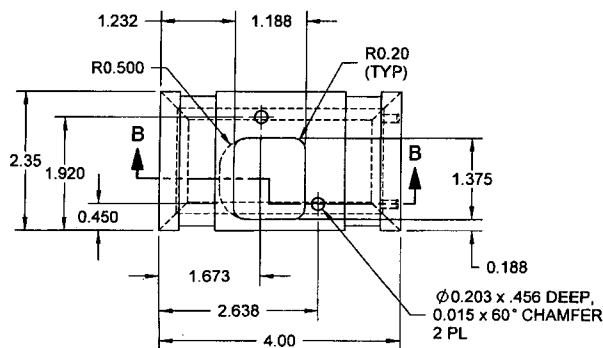
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 2 OF 4
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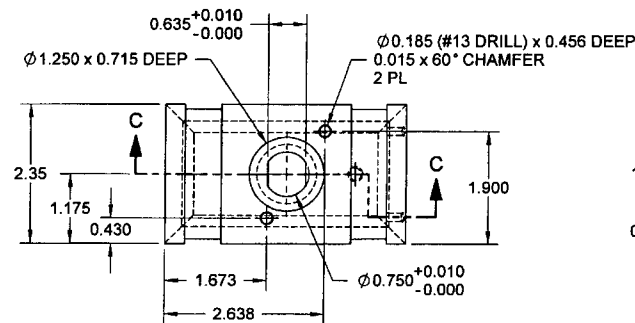
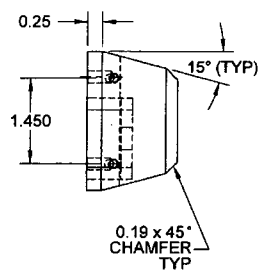
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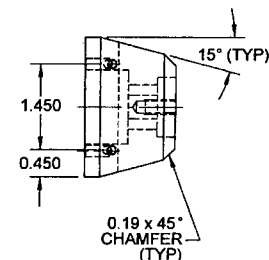
SECTION C-C



D3370-1 BASE



D3370-3 COVER

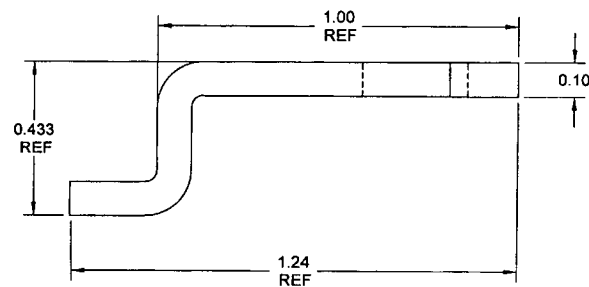
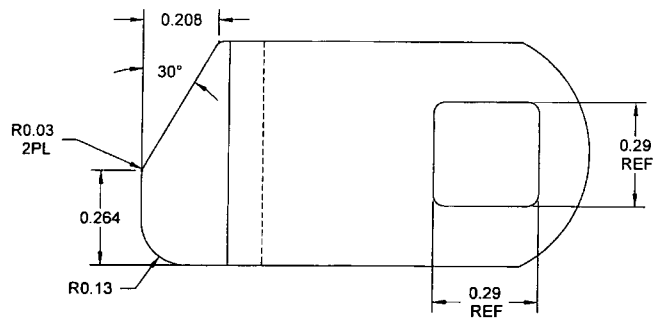


- NOTES:**
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) REF. DART SPEC. M6061T6B
 - 2) COVER INSIDE HOLES PRIOR PAINTING
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

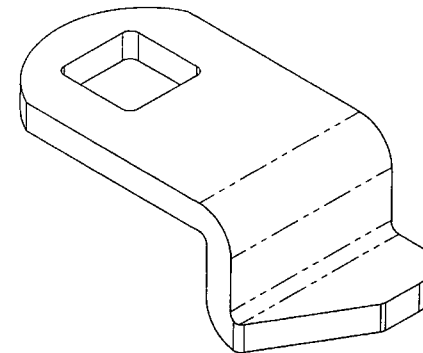
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D3370-5 CAM



- NOTES:**
- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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